

Work Order ID 80329

80329

Page 1

February-17-12 8:28:14 AM

Item ID: D3535-21

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 17/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 02/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

304.048

B12-2-29



110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/26/101



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80329

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Page 2

February-17-12 8:28:14 AM

Item ID: D3535-21 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 17/02/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Form bend & joggle as per Dwg D3535 using DT8261 & DT8326								

140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11h20 OVEN TEMPERATURE:								
	FINISH TIME: 11h50 320° F								

m 118 489

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 Start Date: 17/02/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 02/03/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00

160

QC Memo 0.00

Quality Control

6 BR 1235

170 Identify as per dwg & Stock Location: FPI 0.00

170

Packaging Memo 0.00

Packaging

6X M / 12/03/05

180 QC21- Final Inspection - Work Order Release 0.00

180

QC Memo 0.00

Quality Control

MLJ 12/03/05

12/03/05
 (u)

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NOTE: Date & initial all entries

Picklist Print

February-17-12 8:28:18 AM

Page 1

Work Order ID: 80329

80329

Parent Item: D3535-21

D3535-21

Parent Item Name: Wearshoe

Start Date: 17/02/2012

Required Date: 02/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	275.0165	0.8925	5.636842			

M304S20GA

304/316 .040 Sheet

**

1812-2-29

Location	Loc Qty	Loc Code
MAT020	275.0165	
116623	0.2	
117933	27.3442	
118400	21.1723	
118964	36.5	
119346	29.8	
120604	160	

120604

6

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DART AEROSPACE LTD		Work Order:	80329
Description: Wearshoe		Part Number:	D3535-21
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.188	2		V BUZ	
2.000	+/-0.010	2.000	2		V	
2.000	+/-0.010	2.000	2		V	
1.885	+/-0.010	1.890	2		V	
0.300	+/-0.010	- .361	2		V	
0.300	+/-0.010	- .304	2		V	
5.450	+/-0.010	5.450	2		T BDI	
10.900	+/-0.010	10.900	2		T	
16.350	+/-0.010	16.350	2		T	
21.800	+/-0.010	21.800	2		T	
27.250	+/-0.010	27.250	2		T	
32.700	+/-0.010	32.700	2		T	
6.00	+/-0.030	6.00	2		T	
8.00	+/-0.030	8.00	2		T	
16.00	+/-0.030	16.00	2		T	
24.00	+/-0.030	24.00	2		T	
0.040	+/-0.010	0.036	2		V	

Measured by:	B
Date:	12-2-21

Audited by:	S
Date:	12/03/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.2.02	New Issue	KJ	

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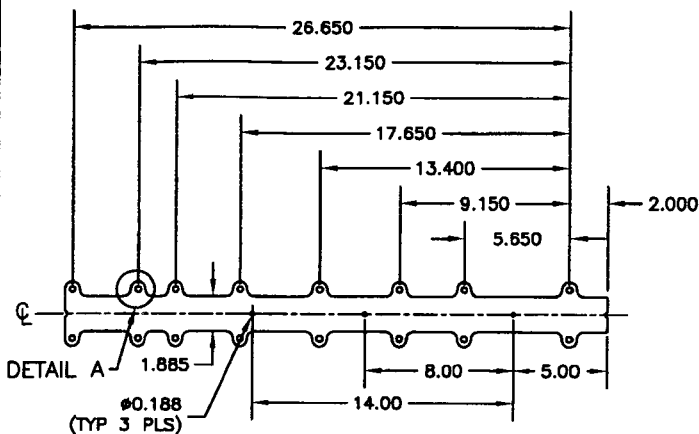
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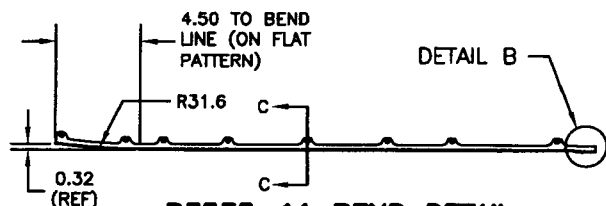
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07.04.24

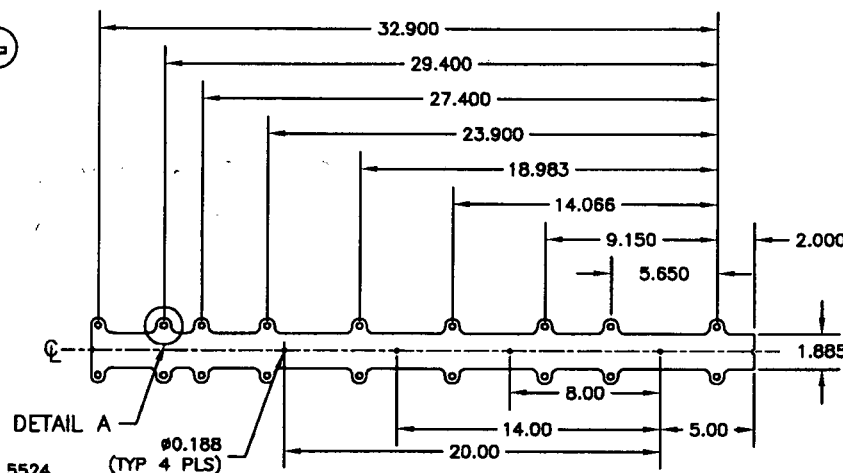
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RETURNED
UNCONTROLLED COPY
SUBJECT: DART P/N 80329
WORK CENTER
NO. 80329 M.C.J
12/02/17



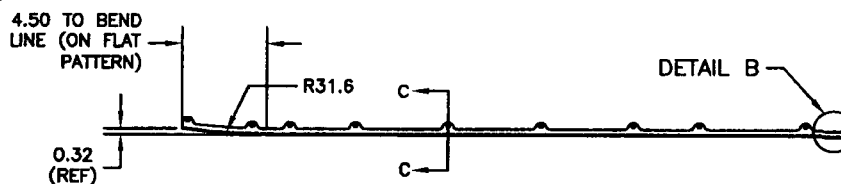
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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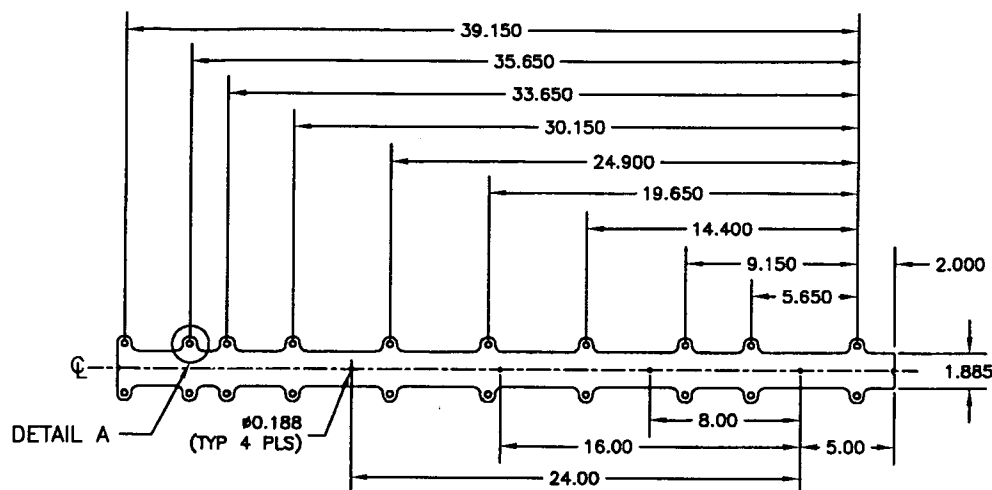
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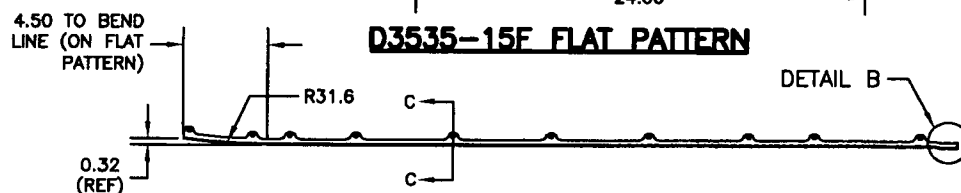
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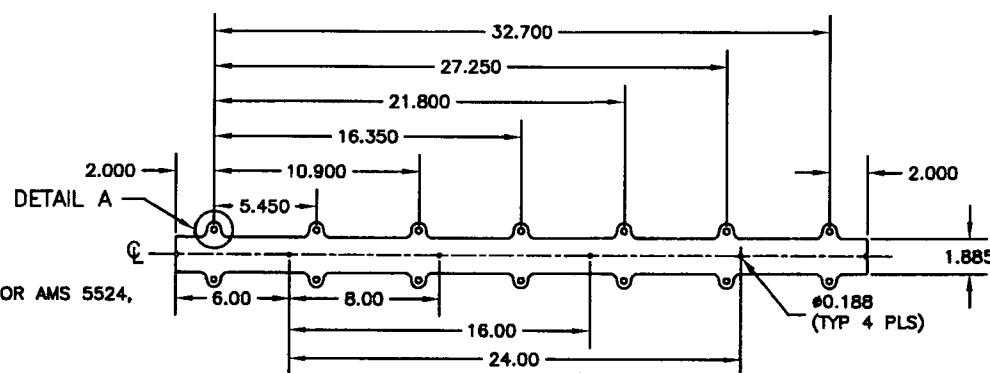
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>		SHEET 2 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:10



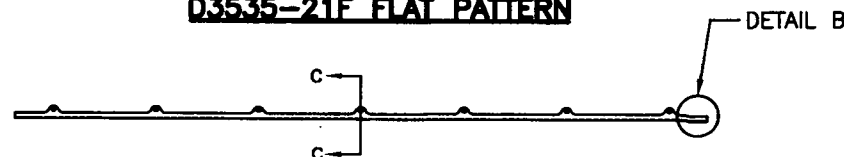
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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NOTE: Date & initial all entries

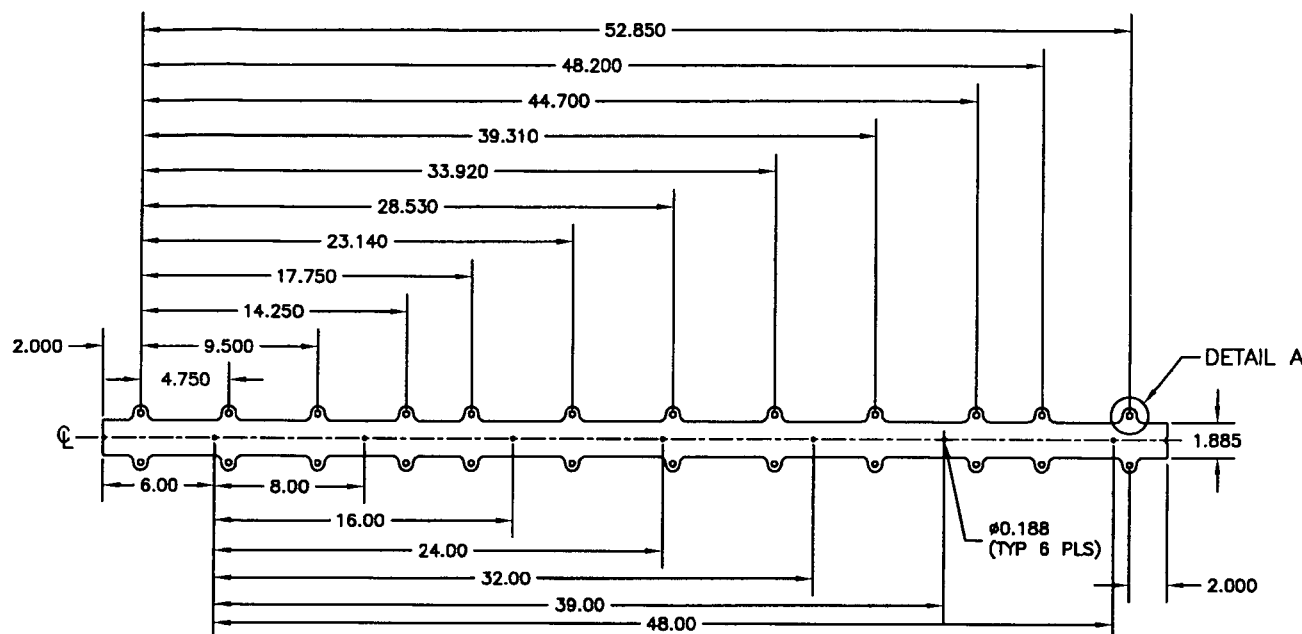
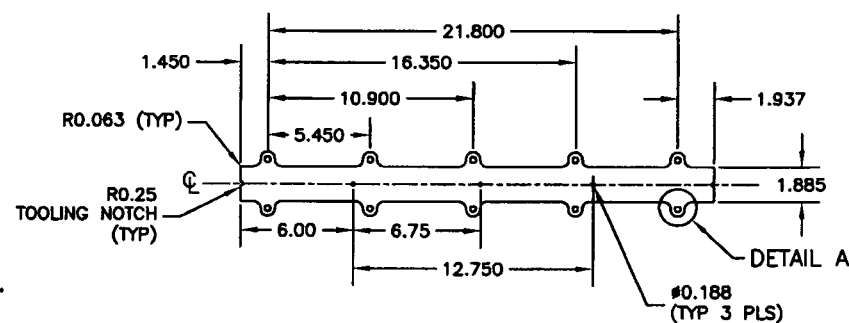
DART**DART AEROSPACE USA, INC.**
PORT HADLOCK, WA

DESIGN	C B	DRAWN BY	PH	DRAWING NO.	D3535	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	TITLE	WEARSHOE	SHEET 3 OF 7
DATE	07.04.17					SCALE 1:10

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07.04.24

80329

**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

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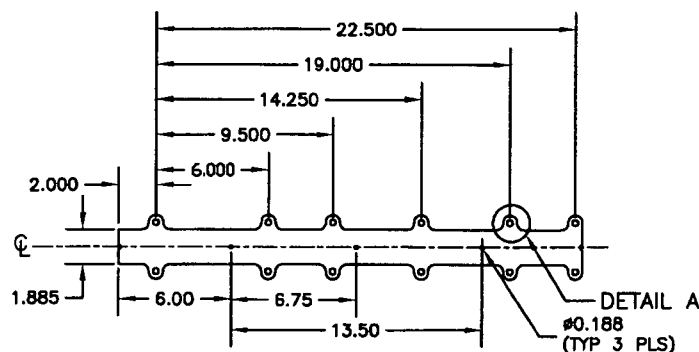
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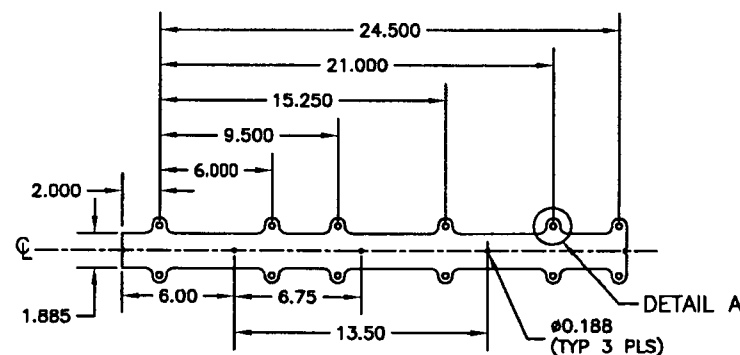
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 4 OF 7
		D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

W/O:		WORK ORDER CHANGES					
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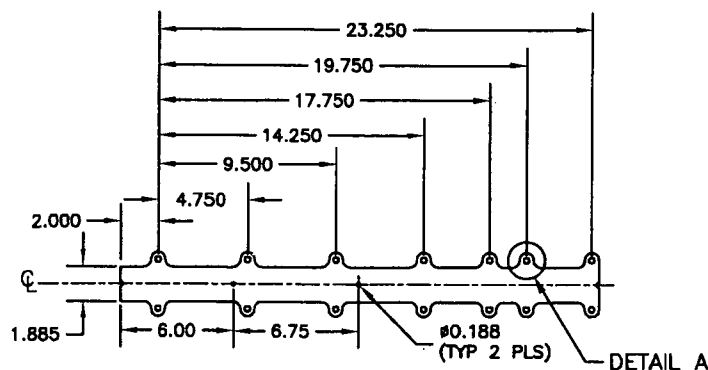
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DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

80329

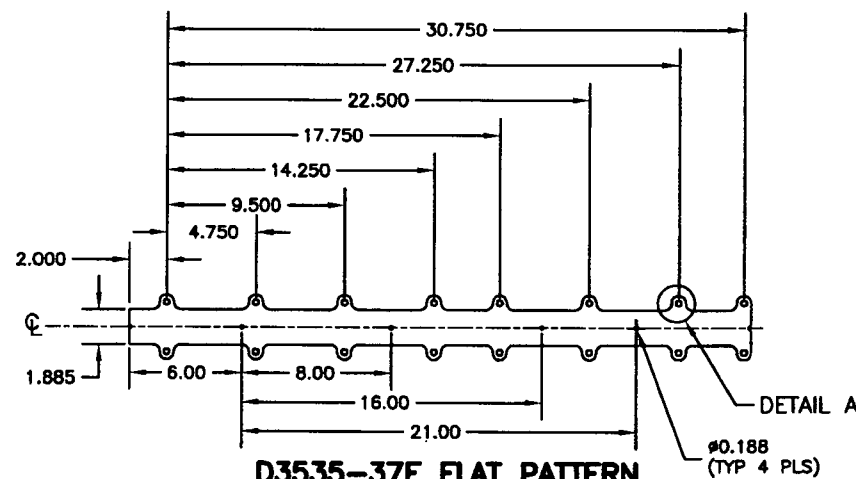
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07.04.24



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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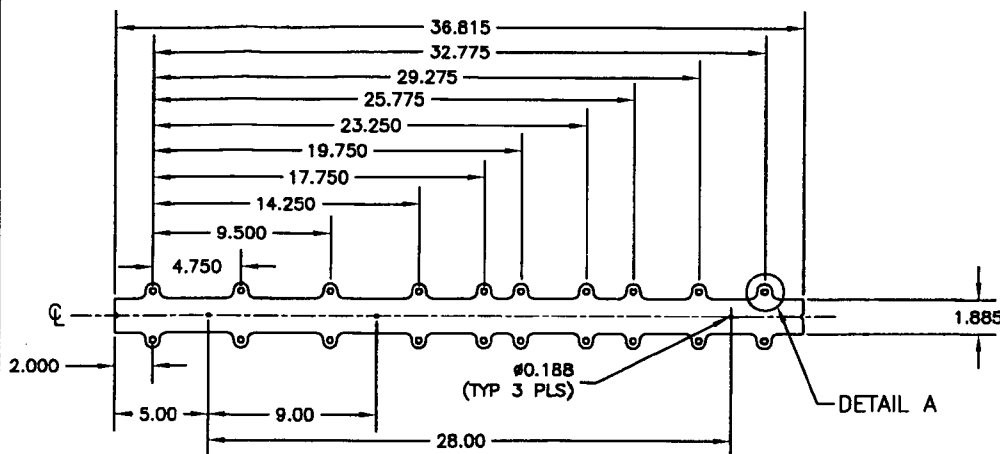
NOTE: Date & initial all entries

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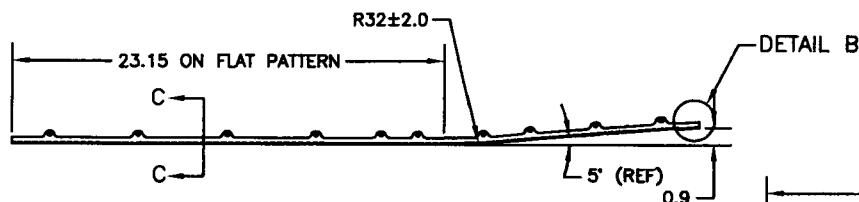
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DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET	6 OF 7	
		REV.	B	

80329

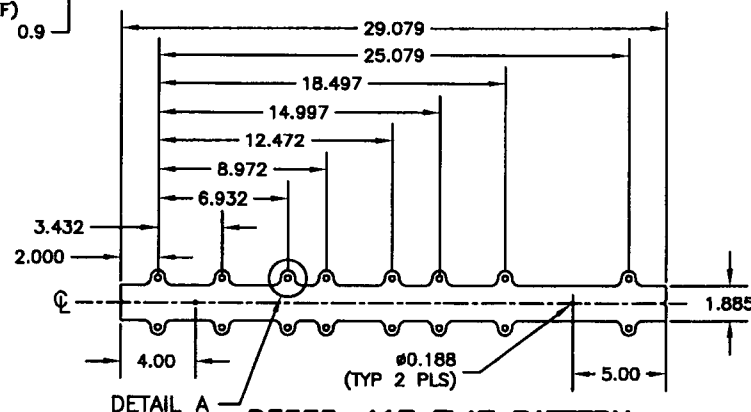
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07 04 24



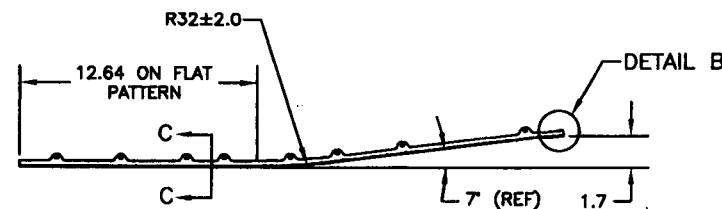
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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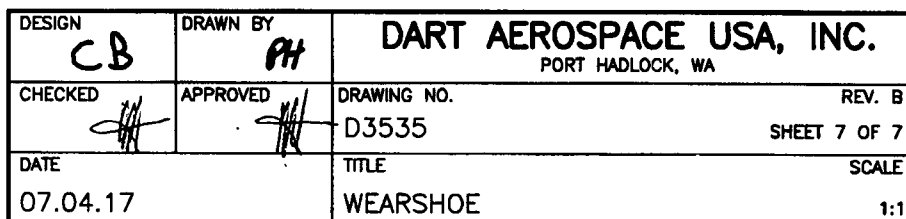
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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RELEASED

07.04.24

DETAIL B

DETAIL A

SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries